Work Orde Wednesday, June												Page 1
Item ID: Revision ID:	D3535-25			Accept				s s	etup S	tart		
	Wearshoe								S	Stop		
Start Date: Required Date: Reference:		Start Qty: 20.00 Req'd Qty: 20.00	1   0   1   0   1   1   1   1   1   1		Cust Item II Customer:	<b>)</b> :						· · · · · · · · · · · · · · · · · · ·
Approvals:	Process Plan	:	Date: 10-6-0	7 Tooling:	Da	te:	-	F		tart		
	QC:		_ Date:	SPC (Y/N):	Da	te:			S	Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr				,			****			+
D3535	Rev E	3					,	į				
100 Waterjet		FLOW WATER JET  Memo		0.00				BIC	>-6-	18		
FLOW CNC Waterje			r Dwg D3535 □Dwg Reecessary	v:\$□Prog Rev:	□2-						S.	
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				. T.	N. 6 . 7	C		
QC Quality Control		Memo		0.00					? <u>-6-(</u>	8	· · · · · · · · · · · · · · · · · · ·	<del></del>
: · · · · · · · · · · · · · · · · · · ·		QC8- Inspect parts - sec	ond check	0.00	١			contr				
QC Quality Control		Memo		0.00	blis	et.		4 25	)		<del></del>	

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W/O:			W	ORK ORDER CHANGES	S				
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	Reso	lution:	Disposition	n:	QA: N/C CI	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR	3)			
DATE	STEP	Description of NC		Corrective Action Section		Verifica	ton	Approval	Approve
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	Approva QC Inspect
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### Work Order ID 59623

Wednesday, June 09, 2010 8:41:47 AM



Page 2

Item ID:

D3535-25

Accept

Setup Start



**Revision ID:** 

Item Name:

Wearshoe

**Required Date: 6/17/2010** 

6/9/2010

**Start Qty: 20.00** 

Req'd Qty: 20.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Date:

SPC (Y/N):

**Tooling:** 

Set Up/

**Run Hours** 

Date: Date: Run

Start

Stop

Reject

Reject

Qty

Stop

Number Stamp

Insp.

Sequence ID/ **Work Center ID** 

130

Brake NC Brake NC

NC BRAKE

Memo

Memo

Operation

Description

0.00

0.00

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-

Form joggle on Punch as per Dwg D3535 using Jig DT8158Identify as D3535-25

50 ido6/23

Tool # Plan

Code

Accept

Qty

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

112588

Memo

0.00

0.00

□OVEN TEMPERATURE:

. Bl 10-6-28

150

<b>Dart Aerospace</b>	Ltd
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W/O:			W	ORK ORDER CHANG	GES									
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# Work Order ID 59623

Wednesday, June 09, 2010 8:41:47 AM



Page 3

Item ID:

D3535-25

Accept

Setup Start

**Revision ID:** 

Start Date:

Item Name: Wearshoe

**Required Date: 6/17/2010** 

6/9/2010

**Start Qty: 20.00** 

Reg'd Qty: 20.00

**Cust Item ID: Customer:** 

Date:

Date:

Reference:

Approvals:

Process Plan:

Date:

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Run

Start Stop

Stop



Sequence ID/ Work Center ID

160

**Ouality Control** 

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan Code

Accept **Qty** 

Reject Oty

Reject Number Stamp

Însp.

170

Packaging

Packaging

Identify as per dwg & Stock Location: FPK

Memo

Memo

0.00

PS 10001 LK

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

W undla 29

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W/O:	T			WORK ORDER C	HANGES					
DATE	STEP		PROCEDURE	CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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			Chief E	ng Chief Eng		Date	Coolid		55. <u></u>	
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# **Picklist Print**

Wednesday, June 09, 2010 8:41:51 AM

Work Order ID: 59623

Parent Item:

D3535-25

Parent Item Name:

Wearshoe

Comments:

IPP Rev:A New Issue 07-02-15 JLM

As per Rev B 07-08-31 JLM IPP Rev:B

Verified By:EC

**Start Date:** 6/9/2010

**Required Date: 6/17/2010** 

**Start Qty: 20.00** 

Required Qty: 20.00

Component Item ID/ Item Name

M304S20GA

Repl	acem
Item	ID

ent Mfg/ Purch Purchased Bin **Primary** Item Location No

Last Location Route Seq ID 100

Unit of Qty on Measure Hand sf 107.9836

Loc Code

Qty per Kit Total

Otv 0.51 10.73684

Issued 13.3

Qty

Date Status Issued

Page 1

Hz 10-6-18

304/316 .040 Sheet

<b>Location</b>	Loc Qty
MAT	104.1278
114574	104.1278
MAT20	3.8558
112885	2.7475
113062	1.1083

114574



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Section A	Chief Eng	Chief Eng	Date	Section	С	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	59423
Description: Wearshoe	Part Number:	D3535-25
Inspection Dwg: D3535 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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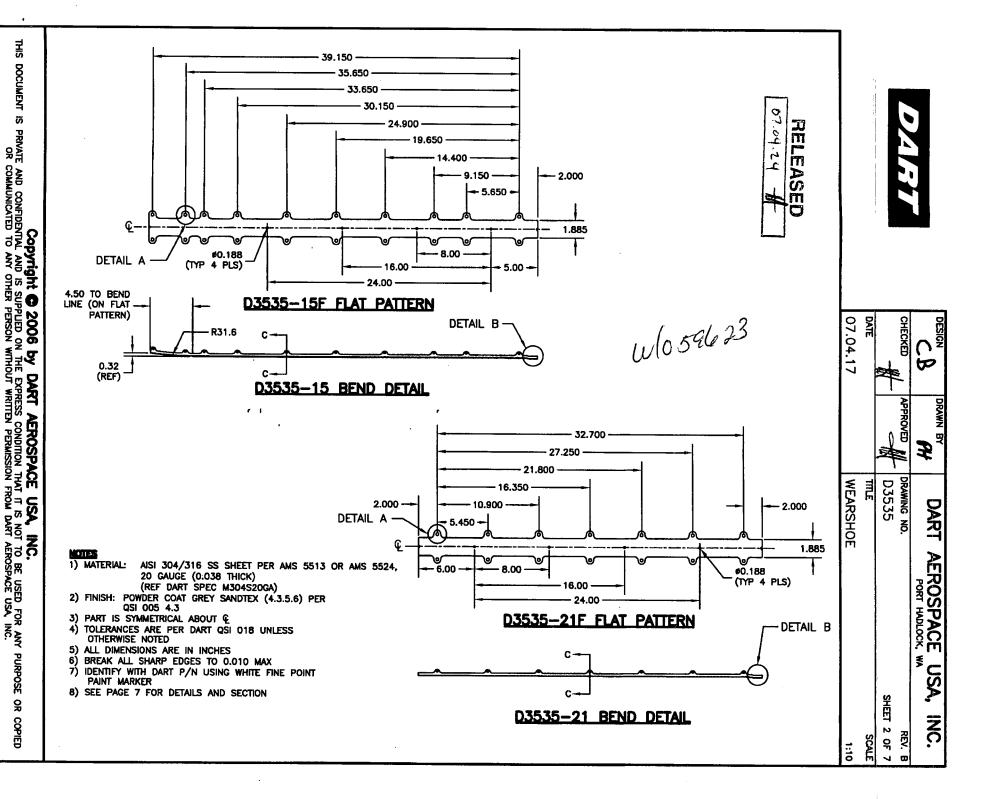
Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
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1.937	+/-0.010	1.939	*			
1.450	+/-0.010	1,453	£			
5.450	+/-0.010	5,456	24			
10.900	+/-0.010	10,908	<u>×</u>			
16.350	+/-0.010	16.350	¥			
21.800	+/-0.010	31.800	×			
Ø0.188	+0.005/-0.001	491,	<b>+</b>			
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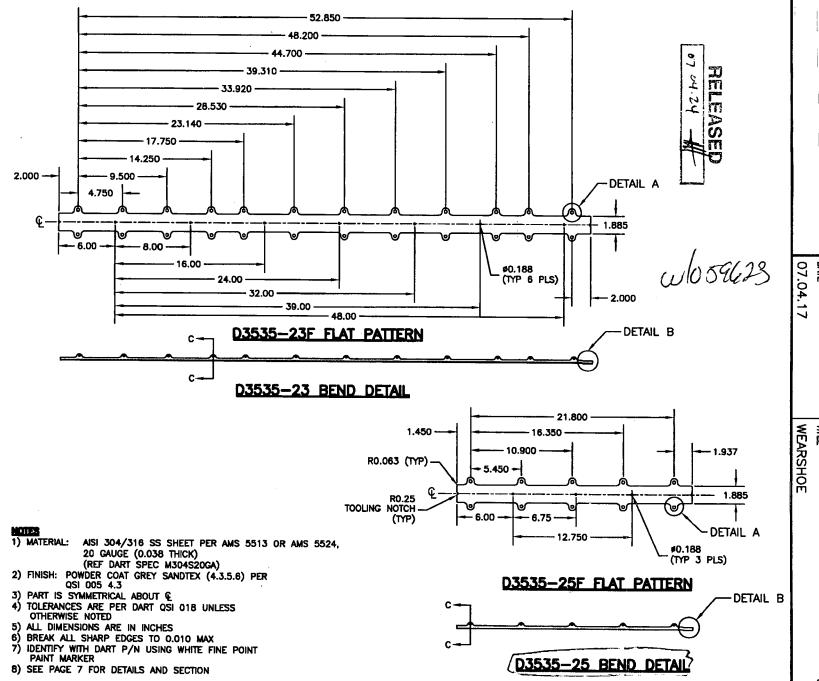
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**PURPOSE** 

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Dart Aerospace Ltd	Dart	<b>Aeros</b>	pace	Ltd
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APPROVED

D3535 DRAWING NO.

SHEET 4

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1:10

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DART

AEROSPACE PORT HADLOCK,

USA,

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07.04.17

**WEARSHOE** 



wlo 59423

D3535-31F FLAT PATTERN

22.500 19.000

> DETAIL A #0.188 (TYP 3 PLS)

14.250

9.500

– 6.000 →

2.000

1.885

D3535-31 BEND DETAIL

2.000 <del>  </del>	24.500 ———————————————————————————————————
Q	6.00 — 6.75 — DETAIL A
	13.50 (TYP 3 PLS)  D35.35—33F FLAT PATTERN



D3535-33 BEND DETAIL

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,

20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3

3) PART IS SYMMETRICAL ABOUT &
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION

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AEROSPACE PORT HADLOCK,

USA,

NC.

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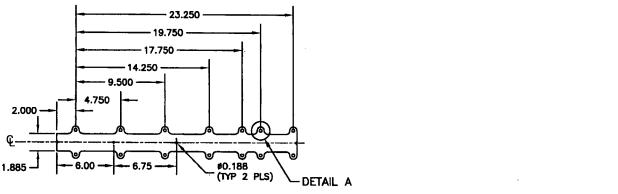
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5 OF 7

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07.04.17

WEARSHOE



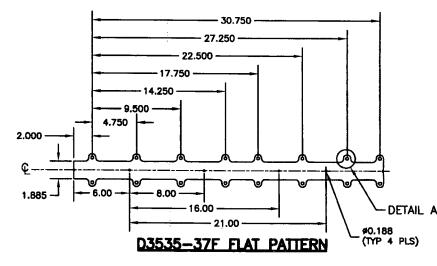
D3535-35F FLAT PATTERN

D3535-35 BEND DETAIL

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**PURPOSE** 

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COPIED

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524. 20 GAUGE (0.038 THICK)
- (REF DART SPEC M304S20GA) 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
- QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT € 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

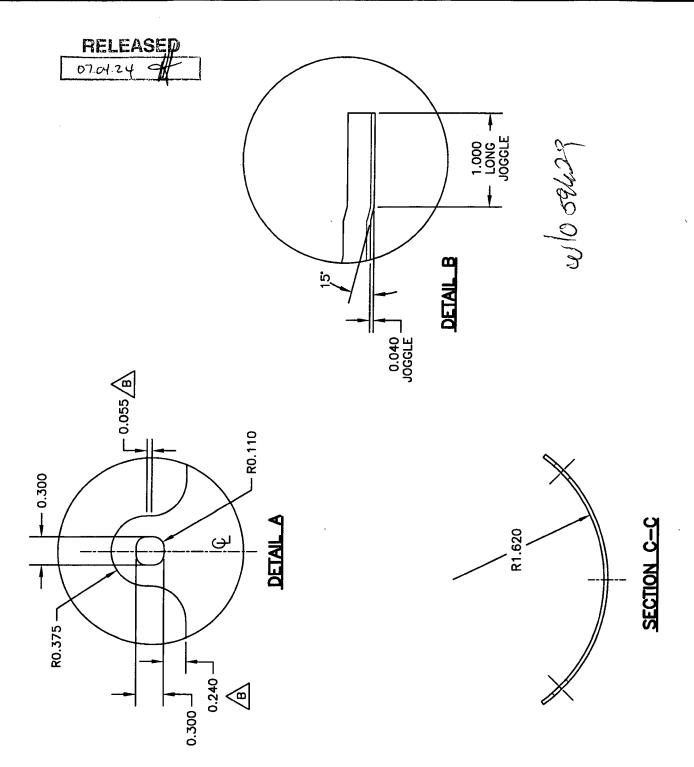


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DATE		TITLE	SCALE
07.04.17		WEARSHOE	1:1



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